



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2563

Job Sheet 179999



Part No: D2563

Job Qty: 1 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/27/18

Job Tracking No:

Due Date: 7/4/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/4/18	0.00	0.00	Start Up Large Fab-2		11 18-6-28
100	Large Fab	1 pcs		7/4/18	0.00	1.47	Large Fab 2		11 18-6-28
110	QC	1 pcs		7/4/18	0.00	0.00	QC9		CPL
120	QC	1 pcs		7/4/18	0.00	0.00	QC5		CPL
130	HandFinish	1 pcs		7/4/18	0.00	0.27	HandFinish1		BFB 18-06-28
140	QC	1 pcs		7/4/18	0.00	0.00	QC7		CPL
150	Large Fab	1 pcs		7/4/18	0.00	1.47	Large Fab 2		11
160	QC	1 pcs		7/4/18	0.00	0.00	QC10		11 18-06-28
170	QC	1 pcs		7/4/18	0.00	0.00	QC5		11 18-06-28
175	HandFinish	1 pcs		7/4/18	0.00	0.27	HandFinish2		BFB 18-06-28
180	Powdercoat	1 pcs		7/4/18	0.00	0.17	Powdercoat1		11 18-7-4
190	HandFinish	1 pcs		7/4/18	0.00	0.27	HandFinish3		BFB 18-07-05
200	QC	1 pcs		7/4/18	0.00	0.00	QC3		88
210	Packaging	1 pcs		7/4/18	0.00	0.00	Packaging3		M/V 1-89
220	QC21-SA	1 Ea		7/4/18	0.00	0.00	QC21		21 11/16/2018

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & Descriptions: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind

150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind

175 - Touch up Alodine as per QSI005

180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME:

11 138839 START 3:05 O.V.T. 3:20 FINISH 3:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	B 164533
D2561	Lug	2 Ea (2 ea)	90-Start up Operation	50 63399
D2564	Mounting Angle	2 Ea (2 ea)	90-Start up Operation	(1x 50 52121) 1x 50 84940
D2673-34	End Plate	1 Ea (1 ea)	90-Start up Operation	50 78838
D2673-34	End Plate	1 Ea (1 ea)	150-Large Fab	50 78838

Wing walk 5080995

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other	AGAINST DEPARTMENT/PROCESS		
Date :	Step #:	QTY Effective :	MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		
		Completed By		
		Lead hand / Supervisor Approval Verification		
		QC / QA Coordinator Approval		
Root Cause ☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
OTHER : _____				

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	1	160	0
	D2561	2	42	0
	D2564	2	41	0
	D2673-34	1	85	0
150-Large Fab	D2673-34	1	85	0
Part Specifications				
Specifications could not be found.				

Plex 6/27/18 1:43 PM dart.lacelle.linda

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____

Part No. _____

NCR No. _____

Date: _____ Ste _____

Description Work O

Master Unit 004136



Job No 179999



Container No: S085061



Part: D2563

Job No: 179999

Serial No/Batch: S085061

Revision:
Inspector:
Exp Date:
Instructions:

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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/28/18

QC / QA Coordinator
Approval

FAULT CATEGORY

Root Cause		FAULT CATEGORY											
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong								
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions								
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance								
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect								
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing								
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved								
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing								
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish								
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread								
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence								
Past Expiry Date	Manufacturing Process												
Misidentified	Past Due												

OTHER :